

205-633-011

Ship Monday 17/05

Work Order ID 58374

May 4, 2010 3:17:45 PM

Page 1

Item ID: D2563

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Weldment Assembly

Start Date: 04/05/2010 Start Qty: 4.00

Required Date: 13/05/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-5-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

POSITIVE
RECALL

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg
D2563 using DT 8343

4- Grind

K.10.03.15

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BE 10/05/17

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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May 4, 2010 3:17:45 PM



Page 2

Item ID: D2563	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Step Weldment Assembly				
Start Date: 04/05/2010 Start Qty: 4.00		Cust Item ID:		
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Reference:			Run Start	
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____			Stop	
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			S 10/05/17			4	0		BE 10/05/17
			(4)						
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
			10-05-17			4	0		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			7 M-12 10/05/17			4X			

W/O:			WORK ORDER CHANGES					
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Work Order ID 58374




May 4, 2010 3:17:45 PM



Page 3

Item ID: D2563 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Weldment Assembly
Start Date: 04/05/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 13/05/2010 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>M112860</u> Large Fab	0.00				4	0		
	Memo	0.00							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				4	0		
	Memo	0.00							
	Quality Control								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

POSITIVE RECALL

EFFECTIVE 10-05-17 AUTH W

RELEASED W DATE 10-05-19

10-5-17

175

touch up abdome per 85005

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 58374

May 4, 2010 3:17:45 PM



Page 4

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Setup Start



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Item Name: Step Weldment Assembly

Stop



Start Date: 04/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30am

320°F

12:00pm

⇒ JH 10/05/17

H BR 10-5-17.

4 Ø

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

11/14/32

H BR 10-5-17.

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-5-17 SJ 40

W/O:			WORK ORDER CHANGES					
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May 4, 2010 3:17:45 PM



Page 5

Item ID: D2563 Accept  Setup Start 
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Item Name: Step Weldment Assembly
Start Date: 04/05/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 13/05/2010 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	<i>PP</i>	<i>58374</i>			<i>10-5-17</i>	<i>AD</i>	
220  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/05/19</i> <i>ME</i> <i>10-5-18</i>

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 4, 2010 3:17:50 PM

Page 1

Work Order ID: 58374

Parent Item: D2563

Parent Item Name: Step Weldment Assembly









Start Date: 04/05/2010

Required Date: 13/05/2010

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	0.0421	1	 3578 50	10.05.17	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
				WA 8	0.0421							
				38023	0.0421							
D2561  Lug		Manufactured	No			100	Each	5.0000	2	 10.05.15		
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
				MEZZ 358430	5					5		
				53616	5					3		
D2564  Mounting Angle		Manufactured	No			100	Each	15.0000	2	 10.05.15		
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
				MEZZ	15					8		
				56292	15							
D2673-34  End Plate		Manufactured	No			100	Each	33.0000	1	 10.05.15		
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
				WA	33							
				57527	33					4		

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

May 4, 2010 3:17:50 PM

Work Order ID: 58374



Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 04/05/2010

Required Date: 13/05/2010

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2673-34 End Plate		Manufactured	No			150	Each	33.0000	1		<i>10-05-17</i>	

Location

Loc Qty

Loc Code

WA

33

57527

33

4

May 4, 2010 3:17:50 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

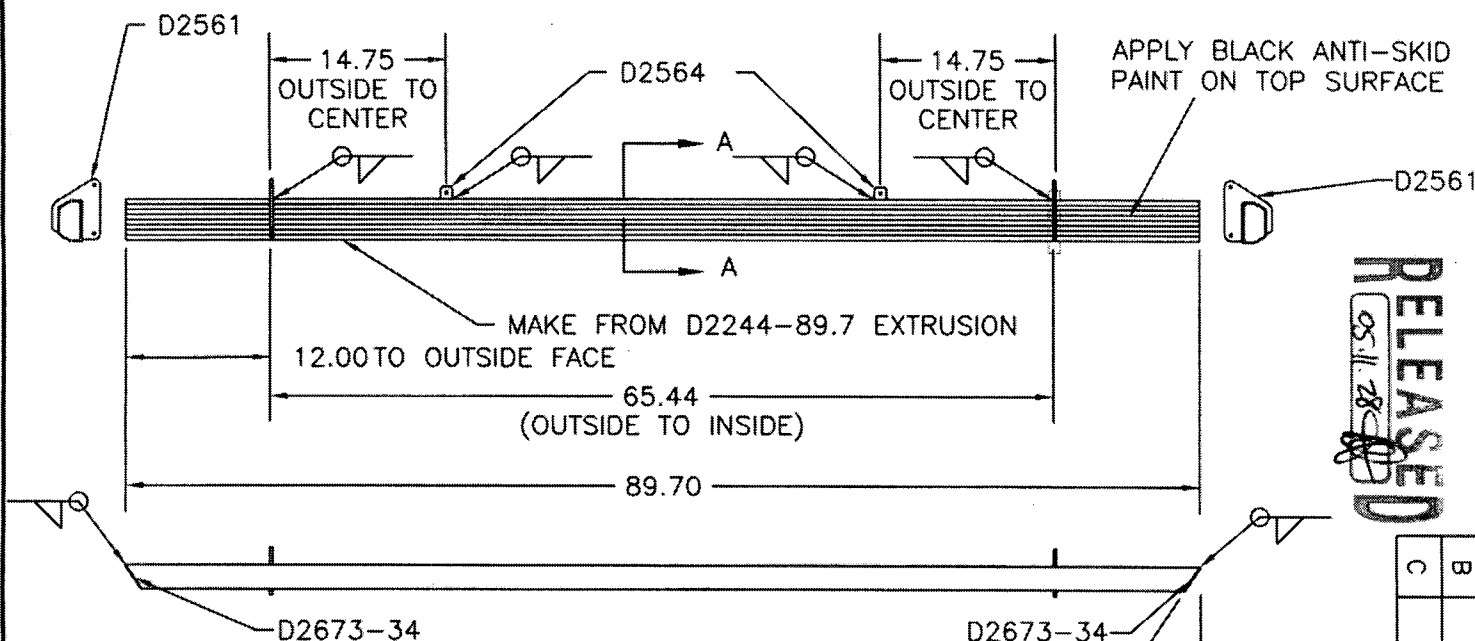
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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RELEASED
05.11.28

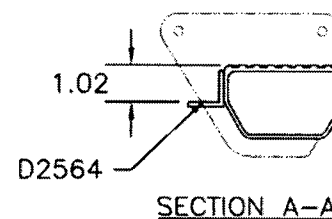


D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58374



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
05.11.14		STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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